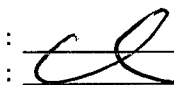
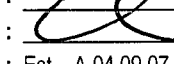


Date: Wednesday, 8/6/2008 2:40:27 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 40908		
Estimate Number	: 11111		
P.O. Number	:	Part Number	: D33048
This Issue	: 8/6/2008 S.O. No. :	Drawing Number	: D3304 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 40908	Material	:
Written By	: 	Due Date	: 8/13/2008 Qty: 16 Um: Each
Checked & Approved By	: 		
Comment	: Est A 04.09.07 New issue KJ/JLM Est B 08.08.06 waterjet EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0683 sf(s)/Unit Total : 1.0920 sf(s)
 304/316 .040 Sheet
 batch: 108118 **IB 8-8-8**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3304
 Dwg Rev: **B**
 Prog Rev: **B**

IB 8-8-8**(18)**

2-Deburr if necessary

8-8-12 JP

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-8-8

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/08/12 (412)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form as per Dwg D3304

83 08/08/25 (12)

Date: Wednesday, 8/6/2008 2:40:27 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40908

Part Number: D33048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/08/25 (418)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 83

8/8/25

(12)

SL

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



U 08.08.25

Date: Friday, 01/08/2008 10:43:17 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	40908		
Estimate Number :	11111		
P.O. Number :		Part Number :	D33048
This Issue :	01/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3304 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	25157	Drawing Revision :	B
	Type :	Material :	
	PURCHASED PARTS	Due Date :	14/08/2008
Written By :		Qty:	16
Checked & Approved By :	JUD 08.8.05	Um:	Each
Comment :	Est A 04.09.07 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING

Issue P/O: _____
 Email or Ship DXF file to vendor
 Laser Cut flat pattern per Dwg D3304(SAME AS -7)
 Possible Supplier: GFI & Industrial Laser
 Material release note is required

Water Set

2.0	D33048F	BRACKET -FLAT
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
 Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:43:17 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40908

Part Number: D33048

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr

2-Form as per Dwg D3304

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

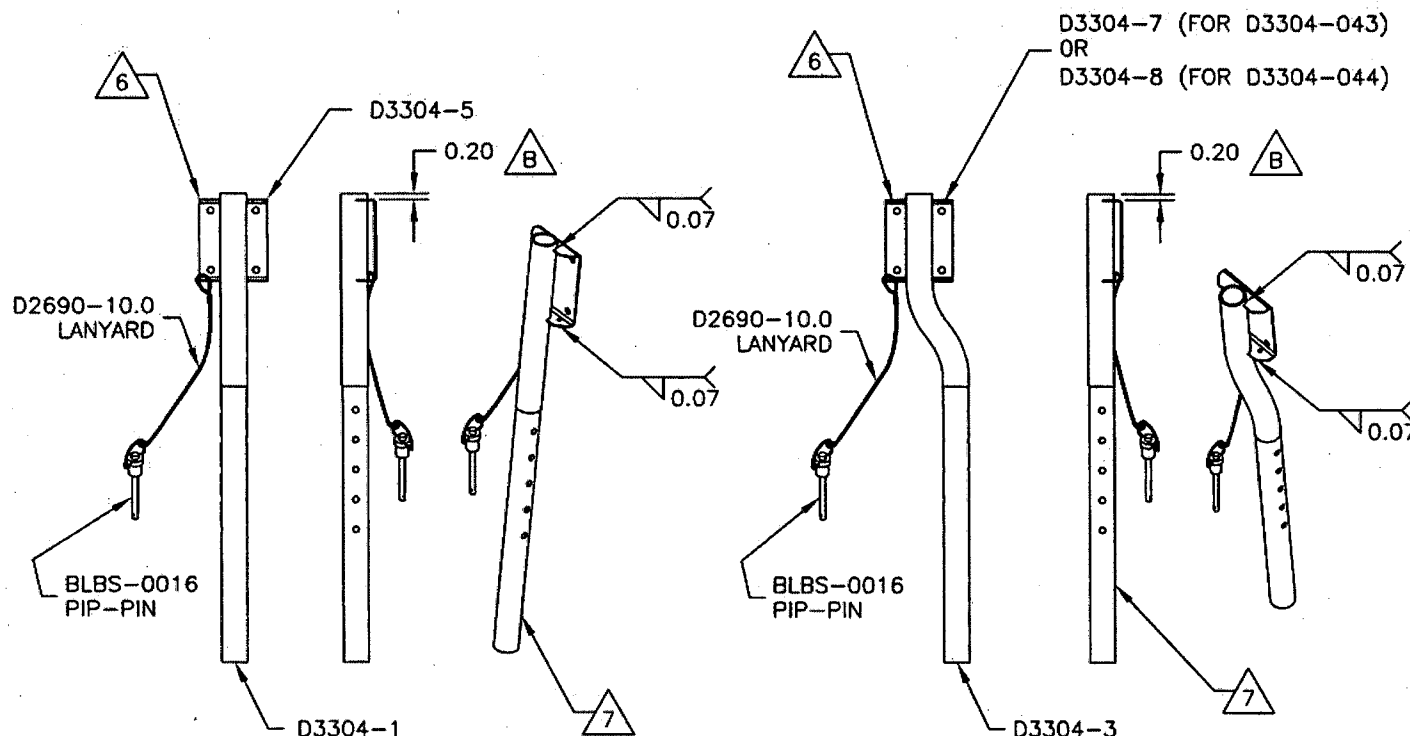
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE	05.07.15			D3304	SHEET 1 OF 4
				TITLE	SCALE
				TUBE ASSEMBLY	1:6
A	04.08.18	NEW ISSUE			
B	05.07.15	UPDATE DIMENSIONS: ADD D3304-7/-8			



D3304-041 TUBE ASSEMBLY

**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
 - 2) WELD PER DART QSI 004
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
 - 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED
05.08.11

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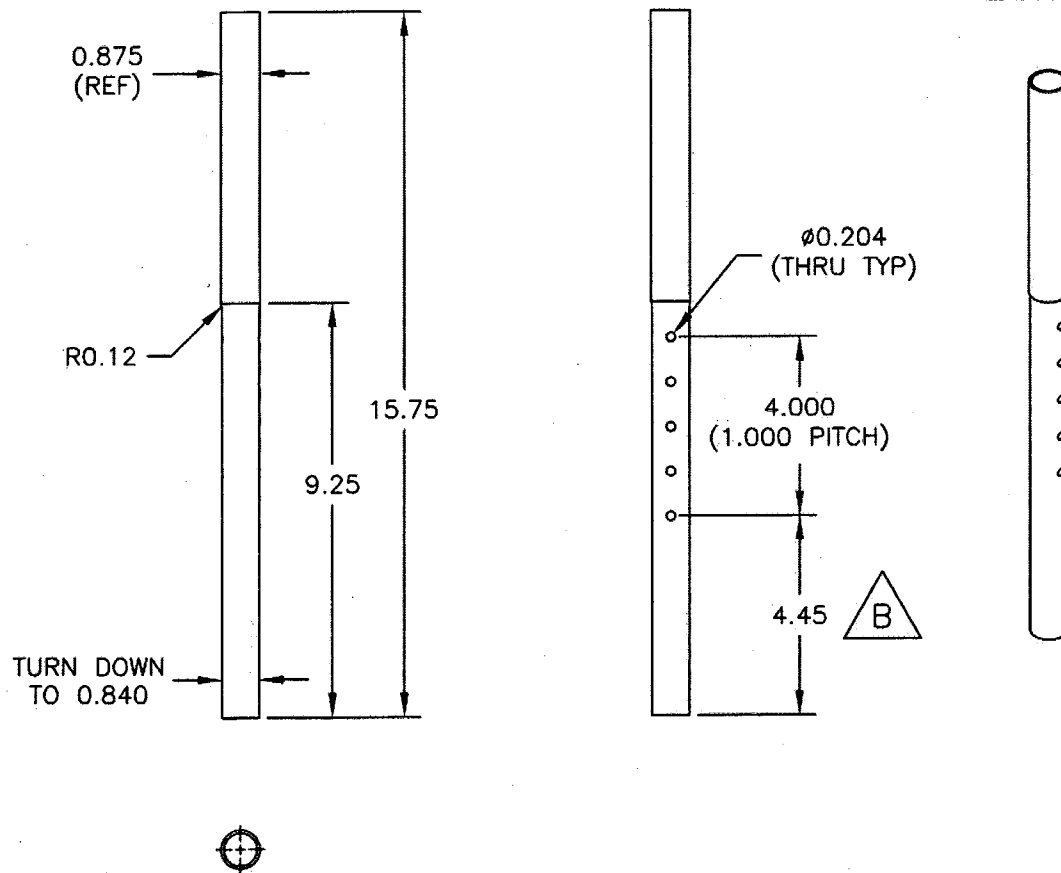
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

RELEASED
05.08.11 *[Signature]*



D3304-1 TUBE

D3304-1 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

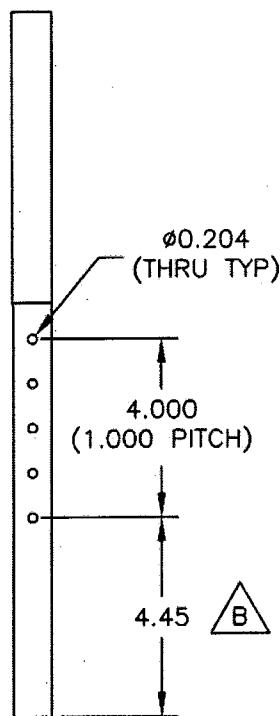
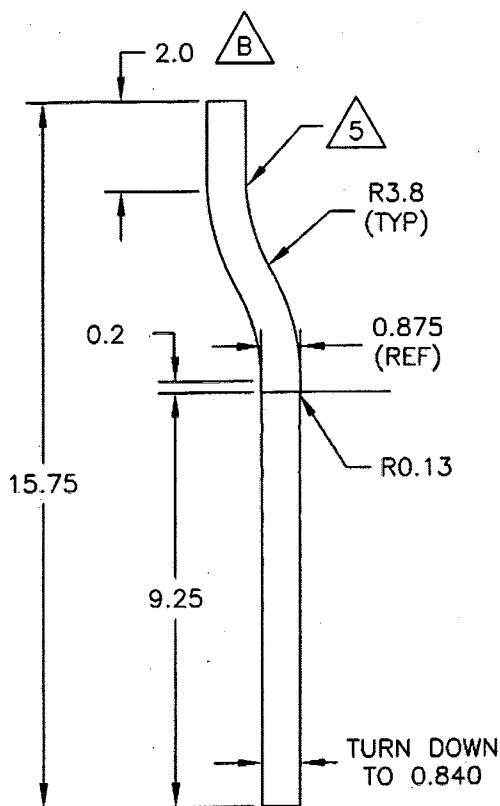
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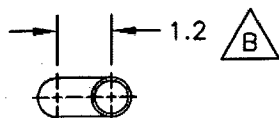
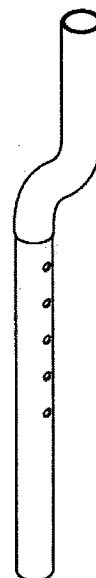
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DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



RELEASED
05-08-11 *[Signature]*



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

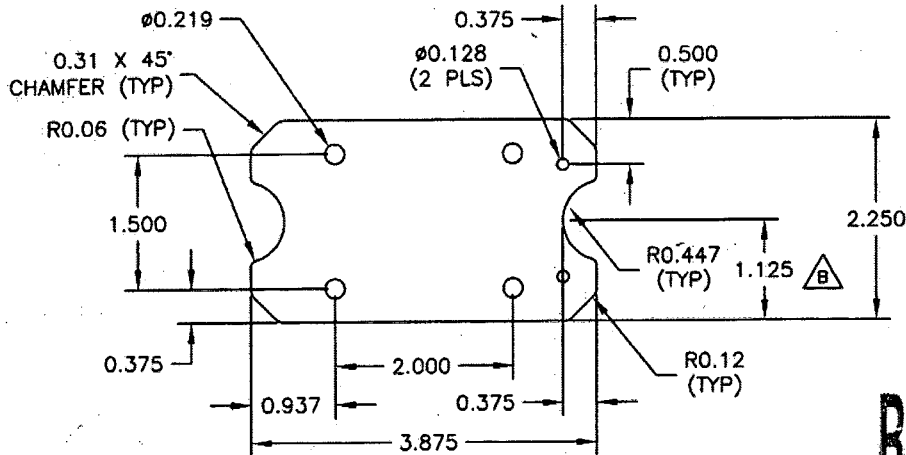
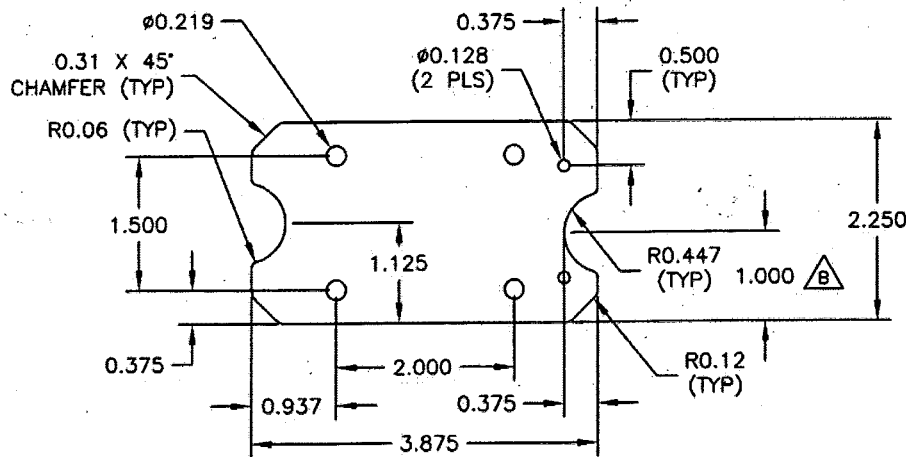
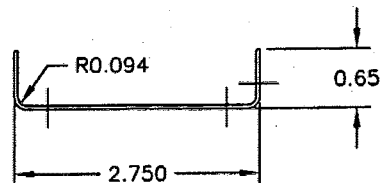
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DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:2

**D3304-5 FLAT PATTERN****RELEASED**
05.08.11**D3304-7/-8 FLAT PATTERN****D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

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NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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